

Wednesday, May 02, 2012 1:04:19 PM

Page 1

Quality Control

12 ~~Ø~~ JM
12-6-6

12 ~~0~~ _____ Jm
 12-6-6

12 m 12' 06" 05"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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84070

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

~~Debur~~ if necessary

N/A

140

0.00

140

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D2144Rev:

V: 1

12

8
12/06/20

150

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

8176472

412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

84070

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

160

Large Fab

Large Fab

Large Fab

Memo

1- Weld corner as per Dwg D2144 & OSI 0042- Grind flush

Set Up/ Run Hours

0.00

0,00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

⑧ PD 12-07-18

170

170

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

82 12-7-18

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

118 _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 84070

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84070

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Item ID: D2144 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 5/2/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating <i>m121841</i>	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>7:30</i> FINISH TIME: <i>8:00</i>	0.00 0.00				<i>12X</i>	<i>0</i>		<i>MT</i> <i>12/07/19</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>	<i>0</i>		<i>BR 12-7-19</i>
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <i>876</i> Memo	0.00 0.00				<i>12x</i>			<i>SP</i> <i>12-7-19.</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84070

Wednesday, May 02, 2012 1:04:20 PM

84070

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Item ID: D2144

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Hinge Bracket

Stop ***NS2***

Start Date: 5/2/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/7/20 JG

MF
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84070

84070

Parent Item: D2144

D2144

Parent Item Name: Hinge Bracket

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D04.05.06ReformatKJ/RF
IPP Rev:E Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			120	sf	94.3720	0.0945	1.134			
**													

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	94.372	
120866	14.246	
120877	80.126	

121626

121626

JM
12-6-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	841070
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.387"	✓		✓	mm01
3.022	+/-0.010	3.022"	✓		✓	
2.468	+/-0.010	2.468"	✓		✓	
1.913	+/-0.010	1.915"	✓		✓	
1.555	+/-0.010	1.557"	✓		✓	
4.126	+/-0.010	4.131"	✓		✓	
3.465	+/-0.010	3.462"	✓		✓	
0.340	+/-0.010	0.343"	✓		✓	
0.625	+/-0.010	0.625"	✓		✓	
1.000	+/-0.010	0.002"	✓		✓	
1.083	+/-0.010	1.084"	✓		✓	
1.660	+/-0.010	1.668"	✓		✓	
2.312	+/-0.010	2.314"	✓		✓	
2.844	+/-0.010	2.843"	✓		✓	
3.294	+/-0.010	3.293"	✓		✓	
Ø0.257	+0.006/-0.001	0.257"	✓		✓	
Ø0.171	+0.005/-0.001	0.171"	✓		✓	
Ø0.320	+0.006/-0.001	0.320"	✓		✓	
0.354	+/-0.010	0.359"	✓		✓	
0.063	+/-0.010	0.057"	✓		✓	

Measured by:	Jm
Date:	12-06-07

Audited by:	[Signature]
Date:	12-06-07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

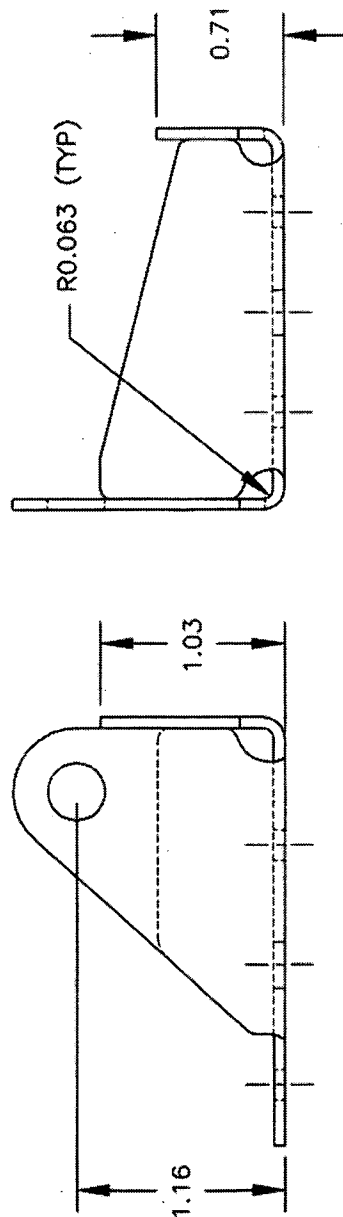
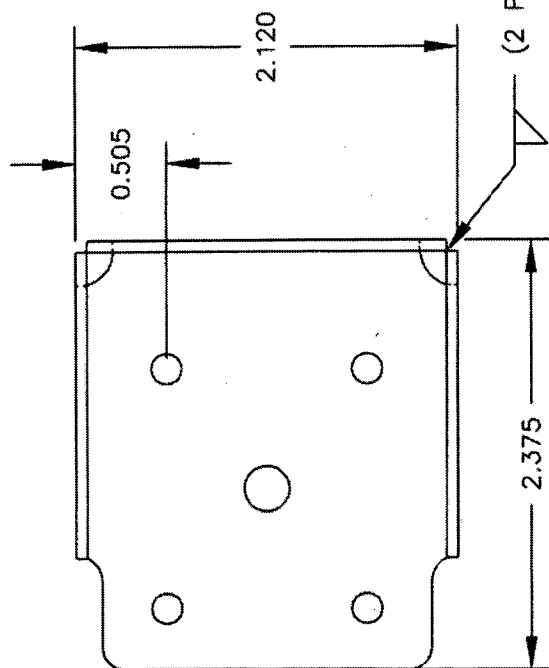
NOTE: Date & initial all entries



RELEASED
98.10.15 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84022

11/2-05-20



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA	APPROVED CA	DRAWING NO. D2144	REV. D SHEET 1 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1
A	95.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

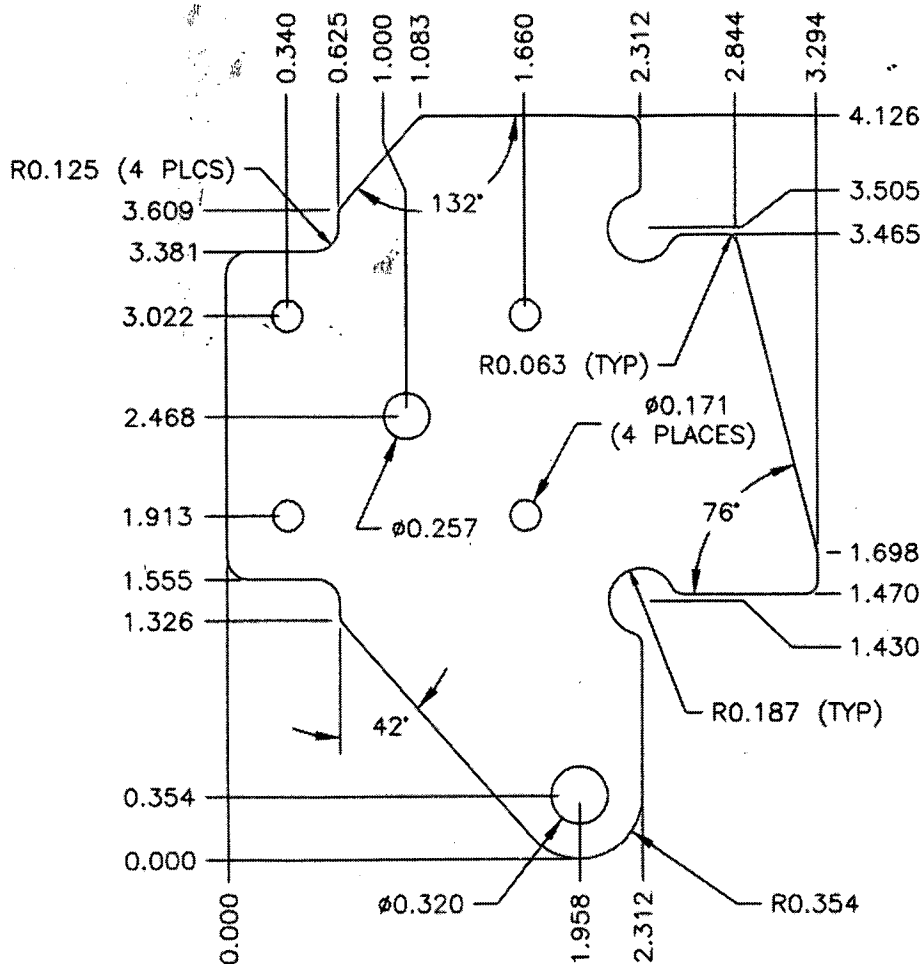
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RJA	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KB

84070



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries